

# Work Order ID 53331-1



October 30, 2009 11:00:03 AM



SPLIT-1

Page 1

Item ID: D2938-1 *BL* Accept  Setup Start   
 Revision ID: C  
 Item Name: Saddle LH Out, 206 Stop   
 Start Date: 30/10/2009 Start Qty: ~~8.00~~ *6*   
 Required Date: 16/11/2009 Req'd Qty: 8.00   
 Reference: Cust Item ID:  
 Customer:

Approvals: Process Plan: *PP* Date: *09-10-30* Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2938	Rev C

100	HAAS CNC VERTICAL MACHINING #1	0.00	<i>8</i>	<i>1</i>					
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HAAS 1  
 HAAS CNC vertical machine #1  
 Memo  
 Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110	CONVENTIONAL MILLING MACHINE	0.00	<i>8</i>	<i>0</i>					
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Mill Conv  
 Conventional Milling Machine  
 Memo  
 Machine Keyway and inspect per attached dimension sheet

120	QC1- Inspect dimensions to dimension sheet	0.00	<i>8</i>	<i>0</i>					
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QC  
 Quality Control  
 Memo  
 0.00


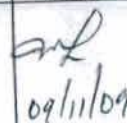
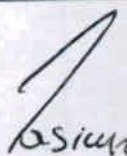
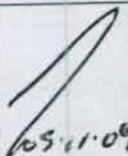
NCR  
 LAST PAGE

# WORK ORDER CHANGES

V/O:						Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty		

Part No: D2938-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: ☒ Yes ☐ No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: 12 Date: 09.12.08

## WORK ORDER NON-CONFORMANCE (NCR)

NCR: <u>53331</u>						Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A	Corrective Action Section B					
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/11/08	100	skid tube holes pattern are too big of .008" and the slot are too large of .005"		Scrap & destroy & replace qty 1 Batch # <u>B46410</u>	 09/11/09	J.L. 09/11/09		 09.11.09
		R.C. operator error. ↓ repress the drill 2 time.						

NOTE: Date & initial all entries

# Work Order ID 53331

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Item ID: D2938-1  
 Revision ID: C  
 Item Name: Saddle LH Out, 206  
 Start Date: 30/10/2009 Start Qty: 8.00  
 Required Date: 16/11/2009 Req'd Qty: 8.00  
 Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	JL 09/11/10						
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	MD 09/11/11			X8			
145  SprayPaint Spray Painting	Spray Painting per QSI005 4.2  Memo	0.00 0.00							

M 09 11 23 6

- 1- Prime B 110918
- 2- Paint Reflect Blue B 113171
- 3- Clear Reflect B 113088

# Work Order ID 53331

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Page 3

Item ID: D2938-1

Revision ID: C

Item Name: Saddle LH Out, 206

Start Date: 30/10/2009 Start Qty: 8.00

Required Date: 16/11/2009 Req'd Qty: 8.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

155

QC14- Inspect Spray Paint

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

45 09-11-24 (K6)

9/11/24 (G) 54

09/11/25 (H)  
09-11-25 (G)

# Picklist Print

October 30, 2009 11:00:07 AM

Page 1

Work Order ID: 53331

Parent Item: D2938-1RevC

Parent Item Name: Saddle LH Out, 206



Comments:

Start Date: 30/10/2009

Required Date: 16/11/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-003RevB 		Manufactured	No			100	Each	0.0000	8.0000			
Saddle Billet, 7075 												

SP 09/11/06

Batch# B46410 x 10

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 53331
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b> D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.118	.115	.118	.120		
B	0.100	0.140		.119	.117	.118	.118		
C	0.100	0.140		.121	.121	.123	.123		
D	0.210	0.230		.225	.223	.223	.223		
E	1.245	1.255		1.248	1.250	1.250	1.250		
F	1.245	1.255		1.248	1.250	1.250	1.250		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		→ .500	.511	.512	.512		
I	1.572	1.582		1.571	1.576	1.575	1.576		
J	2.495	2.505		2.500	2.498	2.498	2.500		
K	0.257	0.262		.259	.260	.260	.260		
L	0.312	0.317		→ .325	.314	.315	.315		
M	0.235	0.240		.235	.235	.235	.240		
N	0.100	0.140		.115	.115	.115	.115		
O	0.540	0.560		.550	.551	.551	.551		
P	0.490	0.510		.498	.501	.502	.500		
Q	3.715	3.725		3.720	3.717	3.719	3.720		
R	2.720	2.760		2.742	2.741	2.741	2.740		
S	0.240	0.270		.255	.252	.254	.254		
T	0.100	0.180		.130	.132	.130	.133		
U	1.625	1.635		1.630	1.628	1.628	1.627		
V	1.362	1.372		1.365	1.365	1.365	1.365		
W	0.316	0.321		.318	.321	.320	.321		
X	1.250	1.270		1.260	1.263	1.260	1.260		
Y	1.565	1.585		1.576	1.578	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by: <i>RF</i>	Audited by: <i>SL</i>
Date: 09/11/10	Date: 09/11/10

Revised by	Approved
RF	
KJ/RF	
KJ/JLM	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 53331
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.100	0.140		.119	.121	.117	.117		
B	0.100	0.140		.116	.120	.118	.120		
C	0.100	0.140		.121	.121	.119	.121		
D	0.210	0.230		.223	.223	.223	.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.512	.512	.512		
I	1.572	1.582		1.572	1.575	1.576	1.576		
J	2.495	2.505		2.499	2.499	2.500	2.500		
K	0.257	0.262		.260	.260	.260	.260		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.237	.238	.237	.237		
N	0.100	0.140		.114	.114	.115	.114		
O	0.540	0.560		.551	.551	.551	.551		
P	0.490	0.510		.501	.501	.502	.505		
Q	3.715	3.725		3.719	3.718	3.721	3.718		
R	2.720	2.760		2.738	2.738	2.740	2.740		
S	0.240	0.270		.255	.255	.255	.257		
T	0.100	0.180		.140	.138	.140	.140		
U	1.625	1.635		1.628	1.628	1.627	1.627		
V	1.362	1.372		1.365	1.366	1.365	1.366		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.259	1.259	1.259	1.255		
Y	1.565	1.585		1.574	1.574	1.574	1.571		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by: <i>Amf</i>
Date: 01/11/08

Audited by: <i>JK</i>
Date: 09/11/10

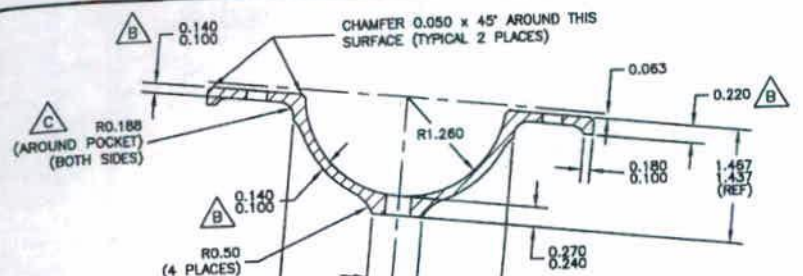
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JA</i>	<i>Shaf</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 53331
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b> D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C		<b>Page 1 of 1</b>

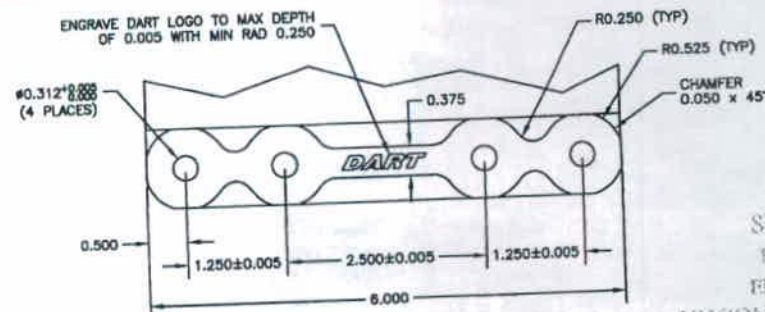
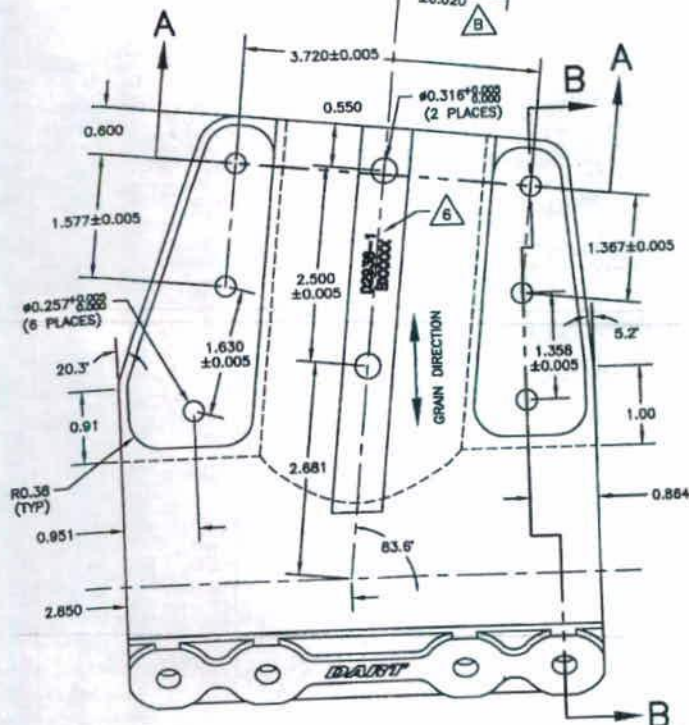
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

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				1	2	3	4		
A	0.100	0.140		.121					
B	0.100	0.140		.124					
C	0.100	0.140		.120					
D	0.210	0.230		.223					
E	1.245	1.255		1.250					
F	1.245	1.255		1.250					
G	2.495	2.505		2.500					
H	0.510	0.515		.512					
I	1.572	1.582		1.576					
J	2.495	2.505		2.500					
K	0.257	0.262		.260					
L	0.312	0.317		.314					
M	0.235	0.240		.237					
N	0.100	0.140		.114					
O	0.540	0.560		.550					
P	0.490	0.510		.502					
Q	3.715	3.725		3.719					
R	2.720	2.760		2.740					
S	0.240	0.270		.255					
T	0.100	0.180		.140					
U	1.625	1.635		1.630					
V	1.362	1.372		1.365					
W	0.316	0.321		.321					
X	1.250	1.270		1.259					
Y	1.565	1.585		1.574					
Z	0.178	0.198		.188					
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

<b>Accept/Reject</b>			<b>Audited by</b> <i>JK</i> <b>Date:</b> 09/11/10	
<b>Measured by:</b> <i>ant</i> <b>Date:</b> 09/11/08			<b>Revised by</b> RF <b>Approved</b> <i>JK</i>	
<b>Rev</b>	<b>Date</b>	<b>Change</b>		
A		New Issue		
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690		
C	07.03.21	Revised per drawing revision C		

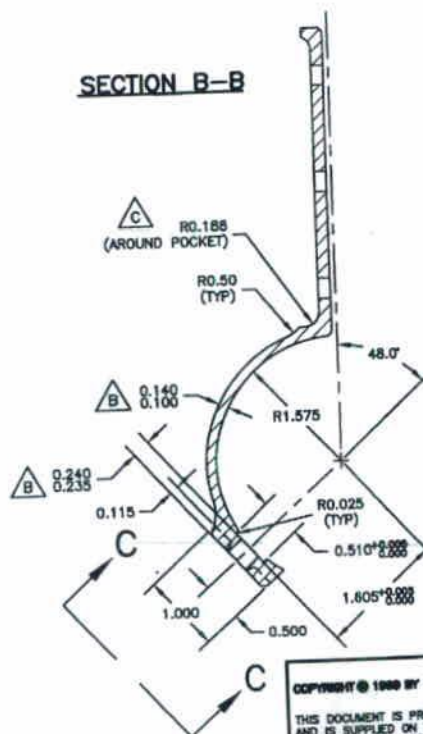


SECTION A-A



VIEW C-C

SECTION B-B



D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	CB	<b>DART</b> DART AEROSPACE USA, INC. BELLJACK, TN
CHECKED	PH	DRAWING NO. D2938
DATE	06.11.09	TITLE SADDLE OUTSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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WORK ORDER  
NO. 53331  
010907

07.02.12